

Work Order ID 81709

\*81709\*

Page 1

March-19-12 8:40:52 AM

Item ID: D4354-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bearpaw Wearplate Assembly

Start Date: 29/03/2012 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/19

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4354

b

100

0.00

\*100\*

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4354-1)

304 0.063

Dwg Rev: B  
Prog Rev: B

2-Debur if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

B12-4-12

(6)

B12-4-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
5-14-50	(2)						5-20-0	708
5-14-50								

NOTE: Date & initial all entries



# Work Order ID 81709

\*81709\*

Page 2

March-19-12 8:40:52 AM

Item ID: D4354-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bearpaw Wearplate Assembly

Start Date: 29/03/2012 Start Qty: 4.00

\*4\*  
\*4\* 2

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

130

0.00

\*130\*

Large Fab

Memo

0.00

Large Fab

1- Weld cups as per dwg  
A/R S.S. ROD BATCH: M121602

2- Apply hardfacing on wearplate as indicated on dwg  
A/R HARDCOAT 2059B BATCH: M122279

PD 12-07-13 / CC

140

QC5- Inspect part completeness to step on W/O

0.00

\*140\*

QC

Memo

0.00

Quality Control

DAS 16 12/07/17

2

12-07-17  
JBL

W/O:		WORK ORDER CHANGES					
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# Work Order ID 81709

March-19-12 8:40:52 AM

**\*81709\***

Page 3

Item ID: D4354-041

Accept

**\*N9000040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bearpaw Wearplate Assembly

Start Date: 29/03/2012 Start Qty: 4.00 **\*4\***

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 4.00 **\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*150\***

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

**\*160\***

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC

Memo

0.00

Quality Control

*LC 12.7.17*

*12/7/17*

*12/7/17*

*WLF  
12-07-17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

March-19-12 8:40:55 AM

Page 1

Work Order ID: 81709

\*81709\*

Parent Item: D4354-041

\*D4354-041\*

Parent Item Name: Bearpaw Wearplate Assembly

Start Date: 29/03/2012

Required Date: 29/03/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11.04.11 NEW ISSUE DD VER:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	441.9860	0.9223	3.883368			

\*M304S16GA\*

304/316 Sheet .063

\*\*

6  
B2-4-12  
G

Location	Loc Qty	Loc Code
MAT020	441.986	
119653	17.35	
120866	73.5	
120877	159.136	
121070	192	

D4379-1

Manufactured No

130 Each 25.0000 10 40

\*D4379-1\*

Wearplate Cup

\*\*

CC 12-7-13

Location	Loc Qty	Loc Code
WA	25	
79649	25	

B81059 → (17)

43



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

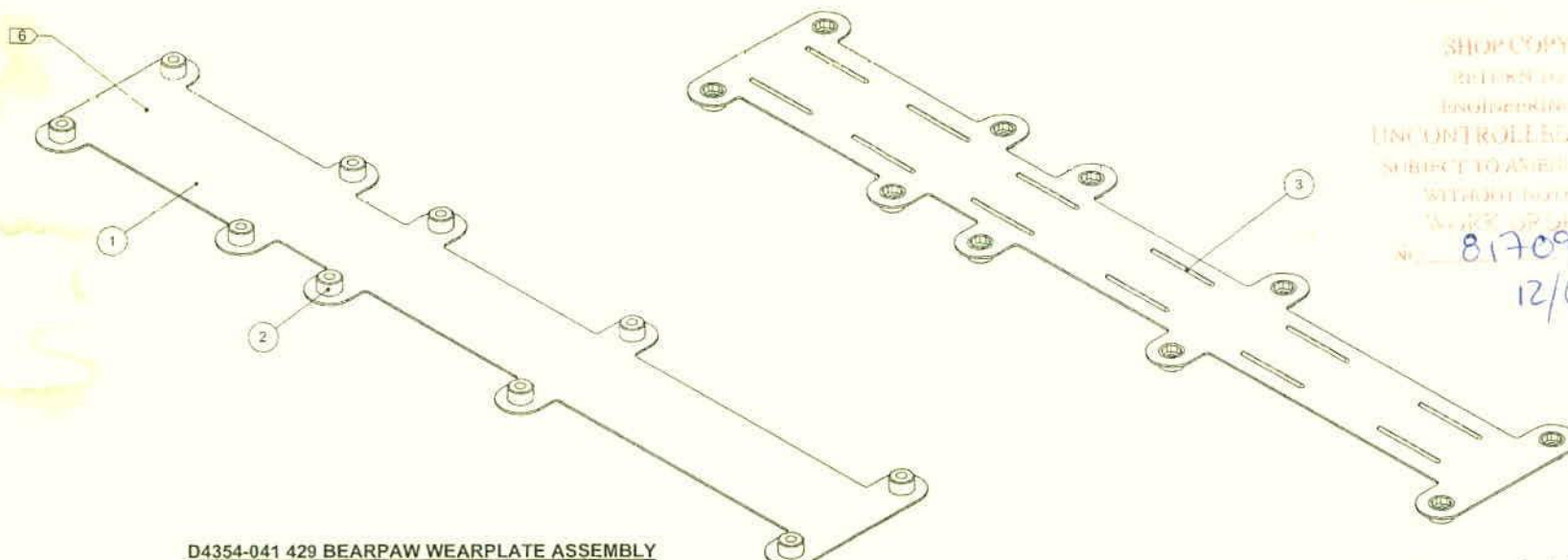
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries



ITEM	QTY	P/N	DESCRIPTION
	X	D4354-041	429 BEARPAW WEARPLATE ASSEMBLY
1	1	D4354-1	429 BEARPAW WEARPLATE
2	10	D4379-1	WEARPLATE CUP
3	A/R	2059B	HARDCOAT



D4354-041 429 BEARPAW WEARPLATE ASSEMBLY

SHOP COPY  
RETURN TO  
INSPECTION  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
81709 MCT  
12/03/19

RELEASED  
2011-05-26

# NOTES

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4354-041" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 1.76 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 12 PL

B	SHT 3, LIGHTENING HOLES DELETED SHT 2 ZONE B1 & B6 HARDCOAT RELOCATED REASON: PROTECTION OF BEARPAW	AJS	11.05.16
A	NEW ISSUE	AJS	11.03.24
REV	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	AJS		
CHECKED	<i>[Signature]</i>		
MFG APPR	<i>[Signature]</i>		
DE APPR	<i>[Signature]</i>		
DATE	11.05.16		

DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4354  
TITLE 429 BEARPAW WEARPLATE ASSEMBLY  
REV. B  
SHEET 1 OF 3  
SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 9120151 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

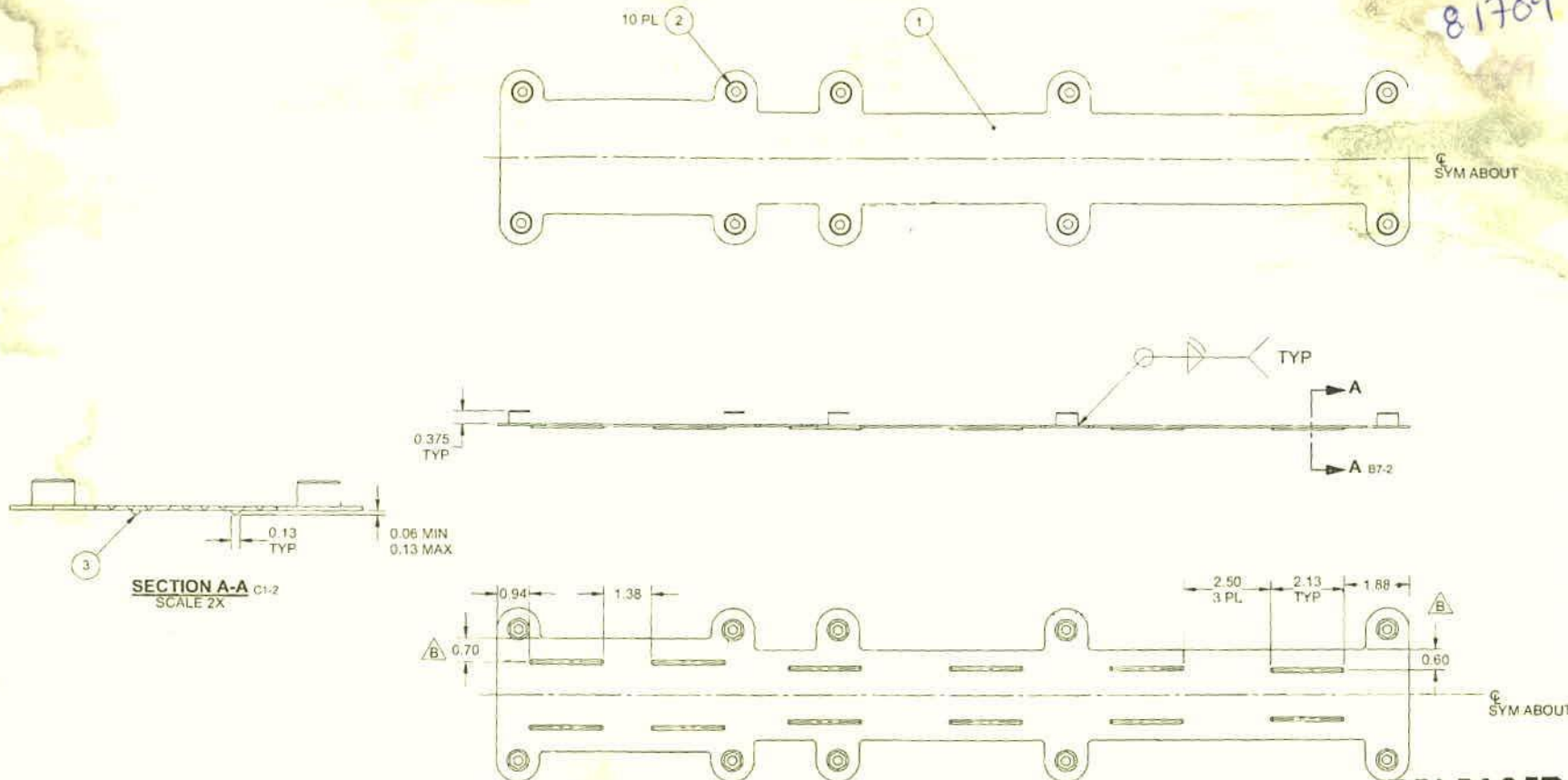
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries



81709



**D4354-041 429 BEARPAW WEARPLATE ASSEMBLY**

**RELEASED**  
2011-05-26

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4354	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	429 BEARPAW WEARPLATE ASSEMBLY	NTS
DATE	11.05.16	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND CONTAINS NO INFORMATION THAT IS UNCLASSIFIED OR CONTROLLED OR OTHERWISE RESTRICTED BY THE NATIONAL DEFENSE AUTHORITY	

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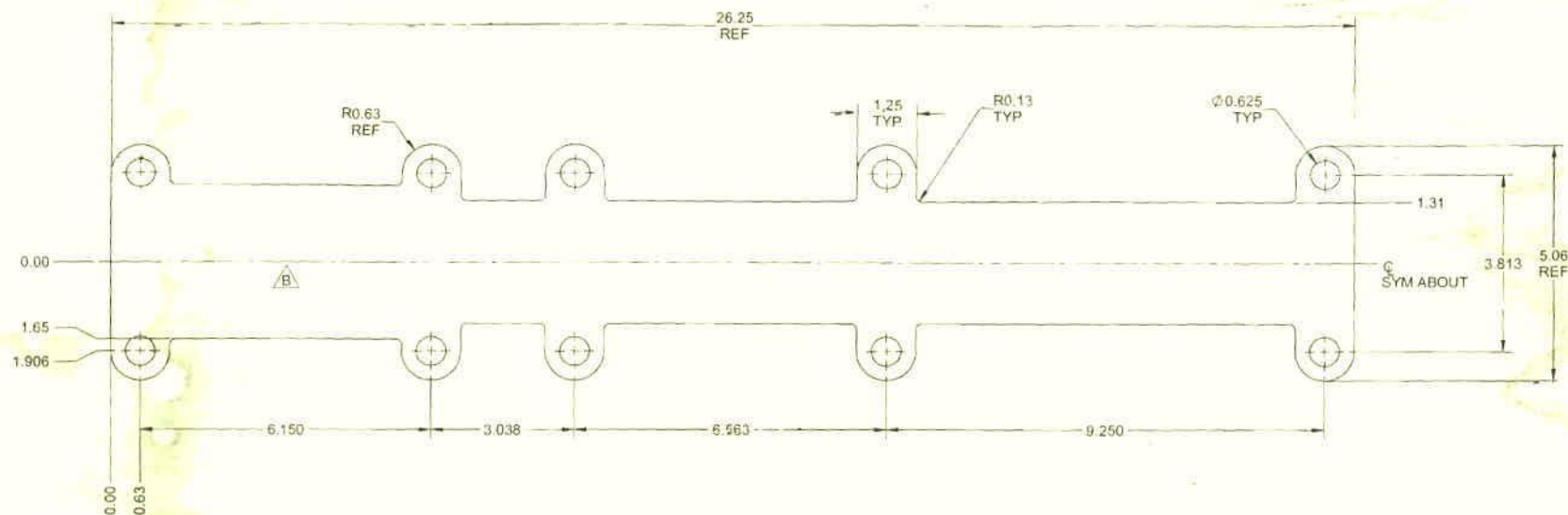
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NOTE: Date & initial all entries



81709



D4354-1 429 BEARPAW WEARPLATE

**RELEASED**  
2011-05-26  
WJ

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)  
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240  
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.52 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	WJ	DRAWING NO.	REV. B
MFG. APPR.	WJ	D4354	SHEET 3 OF 3
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	429 BEARPAW WEARPLATE ASSEMBLY	NTS
DATE	11.05.16	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE EXPIRATION DATE OF 11-05-26 UNLESS OTHERWISE INDICATED BY A NOTE TO THE CONTRARY	

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